

ASAP

Dart Aerospace Ltd.

Date: Friday, 09/01/2009 1:35:33 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARMREST ASSEMBLY
Job Number	: 44534 - 2	Part Number	: D3780041
Estimate Number	: 13346	Drawing Number	: D3780 REVC PRELIM
P.O. Number	:	Project Number	: N/A
This Issue	: 09/01/2009 S.O. No. :	Drawing Revision	: PRELIM
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 30/01/2009
Previous Run	: 41919	Qty:	4 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	Est Rev:A 08-05-26 new issue DD verified by:ec Est Rev:B 08-07-22 revB as per dwg verified by:EC Est Rev:C 09-01-08 rev.C as per dwg DD verified by:ec		

Additional Product

Job Number:



PRELIMINARY ISSUE
 ca. 16
 Per ECN#09-502P

Seq. #:	Machine Or Operation:	Description :
1.0	D3696041	Arm Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Tube Assembly batch: <u>Frans 844542-8</u>	
2.0	D3781041	Cushion Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Cushion Assembly batch: <u>44535</u>	
3.0	D37853	Bracket
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Bracket batch: <u>44540</u>	
4.0	AN96010L	Washer
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s) Washer batch: <u>101340</u>	
5.0	MS21042L3	Nut
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s) Nut batch: <u>1108816</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/01/2009 1:35:34 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMREST ASSEMBLY

Job Number: 44534

Part Number: D3780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS24693C273

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total: 20.0000 Each(s)

Screw

batch: M108246

SS 09/01/15

7.0

MS24693C277

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

batch: M109297

SS 09/01/15

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D3780

****torque screws as per dwg D3780****

See w/o 58885 10-05-20

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker as per dwg (see note 6) and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09.01.23 AUTH U

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

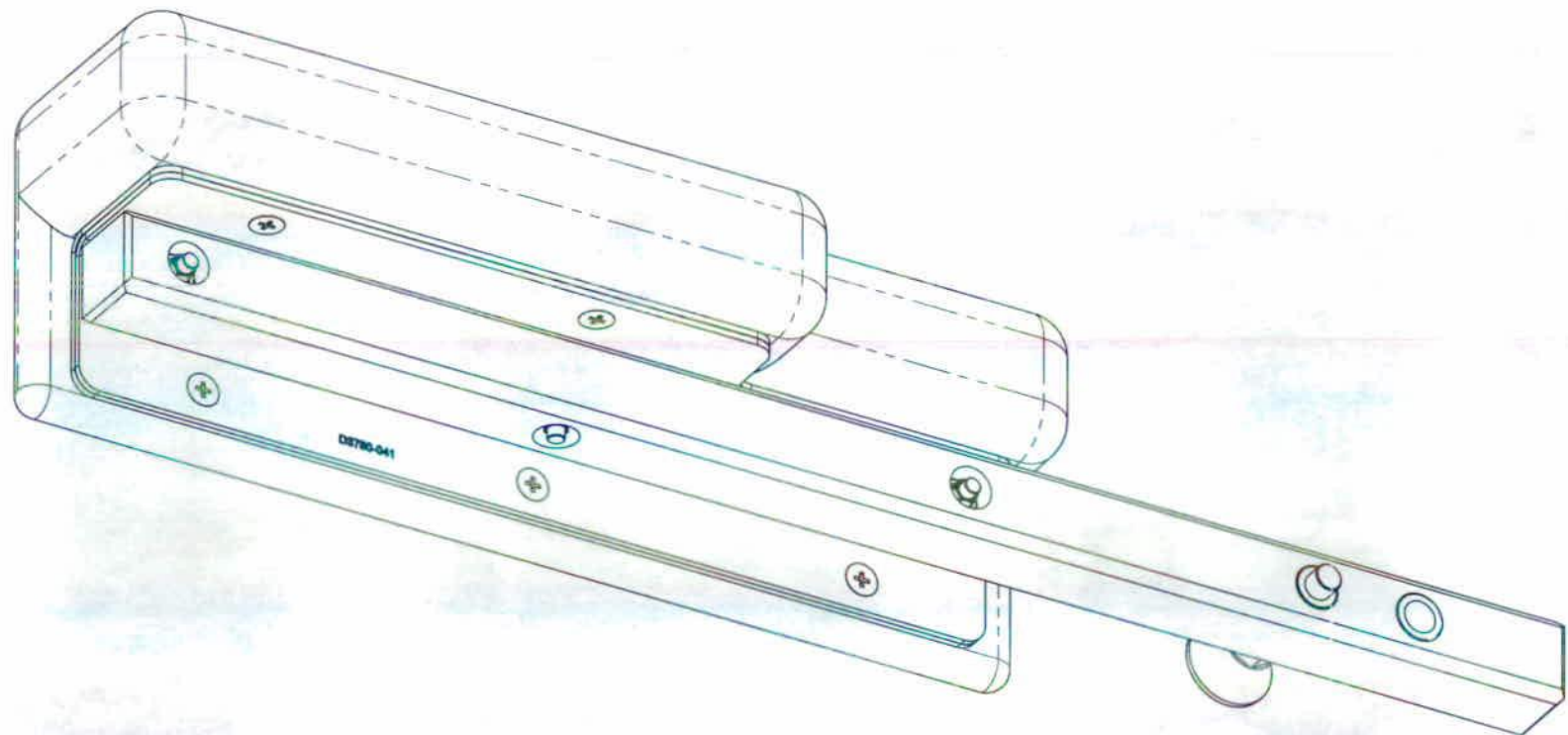
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	CUSHION ASSEMBLY
5	1	D3785-3	BRACKET
7	3	AN960JD10L	WASHER
8	3	MS21042L3	NUT
9	5	MS24693-C273	SCREW
10	3	MS24693-C277	SCREW

C

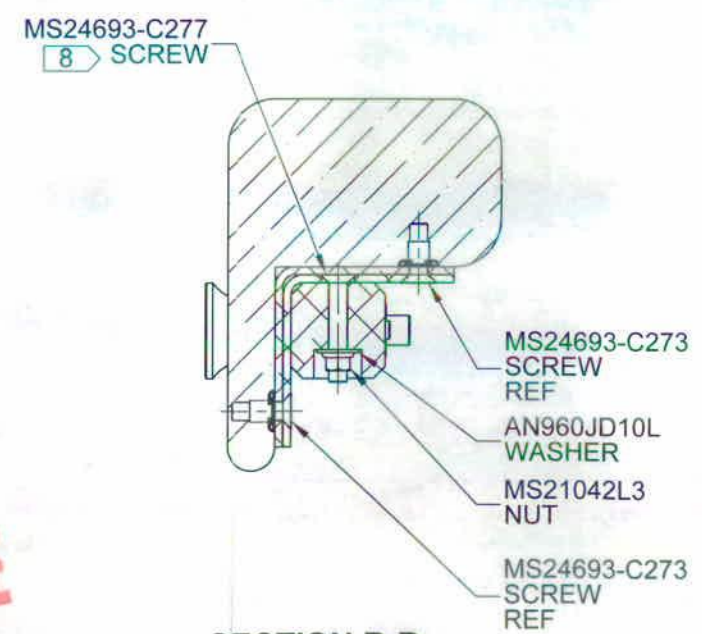
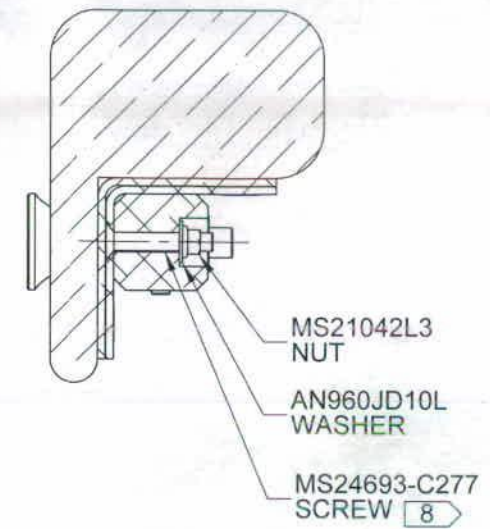
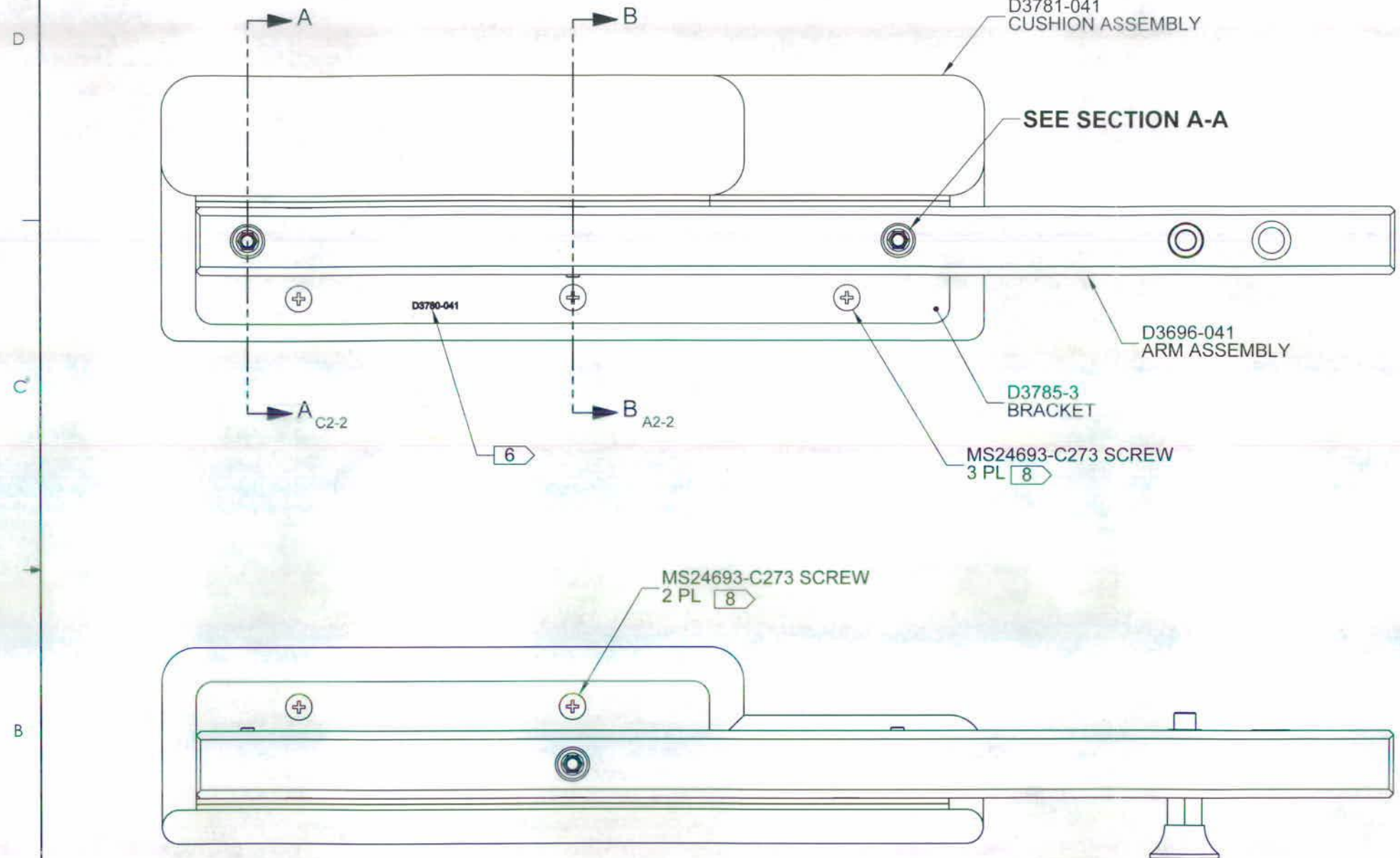


D3780-041 ARMREST ASSEMBLY

PRELIMINARY ISSUE
4.2.16
PER ECN#09.502P

C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3780	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



PRELIMINARY ISSUE
1401.16
PER 081109-5028

D3780-041 NOTES:
1) MATERIAL: NONE
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
7) WEIGHT: 2.61 lbs
8) TORQUE SCREWS TO 20-25 in-lb.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3780	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

